



Dart Aerospace Ltd.
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D2365
Job Sheet 185896



Part No: D2365

Job Qty: 12 ea

Part Name: Wearplate Pip Pin



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/6/18

Job Tracking No:

Due Date: 11/27/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP Rev A Removed from 9 Digit 05-12-05 JLM (IPP Rev:B Now On Waterjet 08-04-04 JLM
Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	12 pcs		11/27/18	0.02	0.35	Waterjet - Flow		SE 18/11/18
120	QC	12 pcs		11/27/18	0.00	0.00	QC8		38
130	HandFinish	12 pcs		11/27/18	0.00	0.24	HandFinish1		D.R. 18/11/18
140	QC	12 pcs		11/27/18	0.00	0.00	QC7		
150	Small Fab	12 pcs		11/27/18	0.00	0.28	Small Fab		DAS
160	QC	12 pcs		11/27/18	0.00	0.00	QC5		38
170	Packaging	12 pcs		11/27/18	0.00	0.00	Packaging3		NOV 15 2018
180	QC21-SA	12 Ea		11/27/18	0.00	0.00	QC21		NOV 15 2018

Part Op 100 - 1-Cut as per Dwg D2365
Descriptions: 150 - Install Insert as per Dwg D2365

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.063	6061-T6 .063 Sheet	.0564 sf (.0047 ea)	100-Waterjet - Flow - 1	5018M
FE-832-EF	Pem Insert D3996-FE-832-EF	24 Ea (2 ea)	150-Small Fab	50927H

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M6061T6S.063	0	176	0
150-Small Fab	FE-832-EF	24	66	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wear Plate	1.250Inches $\pm$ 0.010	1.260 1.240		1.247
2	Wear Plate	1.000Inches $\pm$ 0.010	1.010 0.990		1.001
3	Wear Plate	0.625Inches $\pm$ 0.010	0.635 0.615		0.623
4	Wear Plate	0.250Inches $\pm$ 0.010	0.260 0.240		0.249

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS							
	Rework	☐	Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐
	Scrap	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
	Use-as-is	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
	Suspected Unapproved	☐	Large Fab	☐	Composite	☐	Supplier	☐		

Date : _____ Step #: _____ QTY Effective : _____ MRB (QSI042) Approval _____

Description Work Order Deviation

Area for description of work order deviation.

Part: D2365
 Job No: 185896
 Serial No/Batch: S125269
 Revision:
 Inspector:
 Exp Date:
 Instructions: Various STC's



Completed By _____

Hand / Supervisor Approval Verification

/ QA Coordinator Approval

Dart Aerospace Ltd.

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 CANADA
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Date: 11/06/18

Root Cause			Other		
Environment	☐	No Re-verification	Pressure	☐	Positioned Wrong
Design	☐	Operator	Bending	☐	Outside Dimensions
Doc/Data	☐	Offset/Setup	Center	☐	Over/Under tolerance
Equip/Tooling	☐	Supplier	Cracks	☐	Part Incorrect
Handling/Pre	☐	Training	Crimp/Kink/Ripple/Wave	☐	Part Lost/Missing
Material	☐	Use for Testing	Cuffs	☐	Part Moved
Internal Transport	☐	Poor Information	Crushing	☐	Drawing
Tribal Knowledge	☐	Rushing	Heat Treat	☐	Finish
LOA	☐	Product Improvement	Wave/Twist in Tube	☐	Misread
Substation	☐	Process Improvement	Marks/Chatter	☐	Turning Sequence
Past Expiry Date	☐	Manufacturing Process			
Misidentified	☐	Past Due			
			OTHER :		

5	Wear Plate	0.500Inches $\pm$ 0.010	0.510 0.490	0,498	
6	Wear Plate	0.125Inches $\pm$ 0.010	0.135 0.115	0,125	Radius
7	Wear Plate	0.290Inches + 0.006 - 0.001	0.296 0.289	0,289	Diameter
8	Wear Plate	0.191Inches + 0.006 - 0.001	0.197 0.190	0,191	Diameter

Plex 11/6/18 11:32 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					